

Work Order ID 87805

87805

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July-12-12 1:59:43 PM

Item ID: D2579	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:			Stop		*NS2*
Item Name: Crossbolt Spacer					
Start Date: 7/12/12	Start Qty: 5.00	*5*	Cust Item ID:		
Required Date: 7/12/12	Req'd Qty: 5.00	*5*	Customer:		
Reference: <i>SC 7/12/07/12</i>					
Approvals: Process Plan:	Date:	Tooling:	Date:	Run	Start *NR1*
QC:	Date:	SPC (Y/N):	Date:	Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2579	Rev E								
100	Hardinge CNC LATHE SMALL	0.00							
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Machine as per Folio FA245								
			<i>7/12.07.12</i>					<i>5</i>	
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
			<i>7/12.07.12</i>					<i>5</i>	
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									
			<i>DAS</i>						
			<i>01</i>						
			<i>89</i>						
			<i>12.07.12</i>					<i>5</i>	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>						
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector			
Doc/Data <input type="checkbox"/>												
Equip/Tooling <input type="checkbox"/>												
Operator <input type="checkbox"/>												
Material <input type="checkbox"/>												
Setup <input type="checkbox"/>												
Other <input type="checkbox"/>												
Process <input type="checkbox"/>												
Supplier <input type="checkbox"/>												
Training <input type="checkbox"/>												
Unapproved <input type="checkbox"/>												
FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

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CX 12/7/13

MF

12-07-13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

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Picklist Print

July-12-12 1:59:42 PM

Page 1

Work Order ID: 87805

Parent Item: D2579

Parent Item Name: Crossbolt Spacer

Start Date: 7/12/12

Required Date: 7/12/12

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP E02.06.17Now turned on CobraNG
IPP F 07.07.06 rev E dwg EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.500W.058		Purchased	No			100	f	854.6550	0.3583	1.8857895			
6061-T6 RD Tube .500 x.058W													

Location

Loc Qty

Loc Code

MAT014

854.655

117084

23.242

117890

0.1

119160

1.914

120935

188.287

122051

137.112

122312

504

Handwritten signature and date: 7/12/12

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

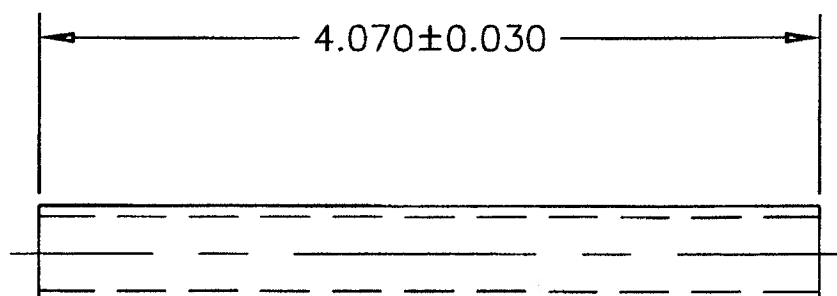
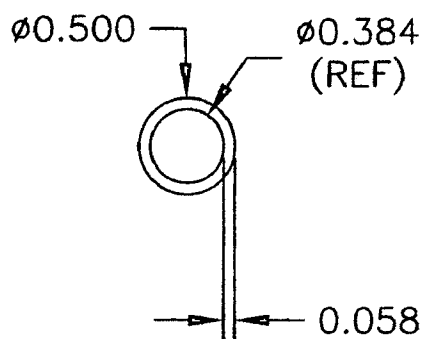
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DESIGN #	DRAWN BY RA	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2579	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE CROSS BOLT SPACER	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	96.12.05	0.065 WALL WAS 0.035 WALL	
C	97.02.21	0.058 WALL WAS 0.065 WALL	
D	99.05.19	4.070 LENGTH WAS 4.100 (TSR A1095)	
E	07.04.17	UPDATE NOTES	

RELEASED
07.06.28



D2579 CROSS BOLT SPACER

D2579 CROSS BOLT SPACER

- 1) MATERIAL: 6061-T6 TUBING PER WW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(REF DART SPEC M6061T6T0500W058)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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